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CLAIMS

We claim:

1. A fastener tape to be mounted in an opening of a reclosable bag having opposing walls, said fastener tape comprising:

an intermediate layer having opposite longitudinal edges and upper and lower surfaces, said intermediate layer including three vertical layers of co-extruded plastic, the upper and lower
5 layers being formed from not more than 4% ethyl vinyl acetate (EVA) and the middle layer being formed from high density polyethylene (HDPE); and

a releasable interlocking profile fastener on said intermediate layer, said profile fastener being substantially coextensive with and laterally spaced from said edges.
2. The fastener tape according to claim 1 further including an elongated non-sealable barrier on one of said surfaces substantially coextensive with and laterally spaced from said edges and said profile fastener.
3. The fastener tape according to claim 1 wherein said intermediate layer is defined by a lip, a fold connected to said lip, an opposite wall connected to said fold, and a lower flange connected to said opposite wall, said lip, opposite wall and lower flange each having an outer surface capable of being sealed to said reclosable bag.
4. The fastener tape according to claim 3 free of said fold.

5. The fastener tape according to claim 3 or 4 further including a peel seal between said lip and said opposite wall.
6. The fastener tape according to claim 3 or 4 further including an upper flange connected to said lip, said upper flange being opposite said lower flange.
7. The fastener tape according to claim 6 further including a peel seal between said upper flange and said lower flange.
8. The fastener tape according to claim 3 or 4 wherein said lip is sealed to said opposite wall at the ends of said fastener tape and wherein said end seals merge with said peel seal.
9. The fastener tape according to claim 7 wherein said upper flange is sealed to said lower flange at the ends of said fastener tape and wherein said end seals merge with said peel seal.
10. An apparatus for fabricating fastener tape for use in the manufacture of reclosable bags comprising:
- a continuous strip of intermediate layer having opposite longitudinal edges and upper and lower surfaces, said intermediate layer including three vertical layers of co-extruded plastic, the upper and lower layers being formed from not more than 4% EVA and the middle layer being formed from HDPE;
- an applicator assembly having first and second sealing means;

means for delivering said intermediate layer to said applicator assembly in a substantially continuous manner;

- 10 means for folding said intermediate layer to obtain a fold; and
means for inserting a continuous strip of profile fastener in said fold;

wherein said first sealing means seals said profile fastener in said fold to said intermediate layer and said second sealing means seals opposing portions of said intermediate layer together in a peel seal.

11. The apparatus according to claim 10 wherein said first sealing means includes a pair of seal bars heated to a temperature in the range of 500 - 600 °F.

12. The apparatus according to claim 10 wherein said second sealing means includes a pair of seal bars heated to a temperature in the range of 240 - 300 °F.

13. The apparatus according to claim 10 further including a pair of rotating belts which deliver the intermediate layer and profile fastener to said first and second sealing means, said belts being positioned between said first and second sealing means and said intermediate layer and said profile fastener so that said first and second sealing means do not directly contact said
5 intermediate layer and said profile fastener.

14. The apparatus according to claim 13 further including a manifold disposed to blow ambient air on said belts so that the temperature of said belts is reduced from an elevated

temperature immediately after said first and second sealing means to a temperature in the range of 85 - 100°F immediately before said first and second sealing means

15. The apparatus according to claim 10 further including a blade disposed to cut said intermediate layer along a fold line defined by said fold to form two separate portions of intermediate layer.

16. A method of manufacturing a fastener tape for attachment in an opening of a reclosable bag, said method comprising the steps of:

dispensing a continuous strip of intermediate layer, said intermediate layer having opposite longitudinal edges and upper and lower surfaces, said intermediate layer including
5 three vertical layers of co-extruded plastic, the upper and lower layers being formed from not more than 4% EVA and the middle layer being formed from HDPE;

delivering said intermediate layer to an applicator assembly in substantially a continuous manner;

folding said intermediate layer to obtain a fold;

10 inserting a continuous strip of profile fastener in said fold;

attaching said profile fastener to said intermediate layer; and

sealing opposing portions of said intermediate layer to one another in a peel seal.

17. The method according to claim 16 including the additional step of slitting said intermediate layer along a fold line defined by said fold to form two separate portions of

intermediate layer.

18. A reclosable bag comprising:

a body having an opening and opposing walls; and

a fastener tape mounted in said opening, said fastener tape comprising a profile fastener carried by an intermediate layer, said intermediate layer being defined by a lip and a wall

5 opposite said lip;

wherein portions of said lip and said opposite wall are sealed to opposite bag walls;

wherein said lip is peel sealed to said opposite wall on a side of said profile fastener adjacent said bag opening;

wherein said lip is sealed to said opposite wall at the ends of said fastener tape; and

10 wherein said end seals merge with said peel seal.

19. A reclosable bag comprising:

a body having an opening and opposing walls;

a fastener tape mounted in said opening, said fastener tape comprising a profile fastener carried by an intermediate layer, said intermediate layer being defined by an upper flange, a lip

5 connected to said upper flange, a lower flange opposite said upper flange, and an opposite wall connected to said lower flange;

wherein portions of said lip and said opposite wall are sealed to opposite bag walls;

wherein said upper flange is peel sealed to said lower flange on the side of said profile fastener opposite said bag opening;

10 wherein said upper flange is sealed to said lower flange at the ends of said fastener tape,
and

wherein said end seals merge with said peel seal.

20. The method according to claim 18 or 19 wherein said opposing bag walls are sealed together by said end seals.